

Date: Tuesday, 13/05/2008 9:30:16 AM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEARPLATE		
Job Number	: 39233					
Estimate Number	: 12731					
P.O. Number	:			Part Number	: D353535	
This Issue	: 13/05/2008		S.O. No.	: D3535 REV B		
Prsh Rev.	: NC			Project Number	: N/A	
First Issue	: / /		Type	: SMALL /MED FAB		
Previous Run	: 38760			Drawing Revision	: B	
Written By	:			Material	:	
Checked & Approved By	: <u>JUL 08. S. 13</u>			Due Date	: 30/05/2008	
Comment	: Est Rev:A New Issue 07-02-15 JLM			Qty:	20 Um: Each	
	Est Rev:B As per Rev B 07-08-31 JLM Verified By:EC					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S20GA	304/316 .040 Sheet
		 Comment: Qty.: 0.8423 sf(s)/Unit Total : 16.8462 sf(s) 108118 X 2 + 6 6.8 304/316 .040 Sheet 107909 X 3 + 2 4.5 (M304S20GA) Batch: <u>108118-2</u> <u>IB 8-5-27</u>
2.0	WATER JET	FLOW WATER JET Comment: FLOW WATER JET 1-Cut as per Dwg D3535 Dwg Rev: <u>B</u> <u>IB 8-5-27</u> Prog Rev: <u>B</u>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>IB 8-5-27</u>
4.0	QC8	SECOND CHECK Comment: SECOND CHECK <u>5/08/05/27</u>
5.0	BRAKE NC	NC BRAKE Comment: NC BRAKE 1-Deburr if necessary 2-Form on Brake as per Dwg D3535 using Jigs DT8261and DT8326. 3-Identify as D3535-35. <u>SB 08/05/27</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 13/05/2008 9:30:16 AM  
User: Julie Lecocq

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 39233

Part Number: D353535

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



5/08/05/22X13

Comment: INSPECT WORK TO CURRENT STEP

7.0 POWDER COATING

POWDER COATING



m/05642



13X

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: 7:30

OVEN TEMPERATURE: 320

FINISH TIME: 8:00

M.F 08/05/28

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



13

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP417

22/6/ 08/05/28 13

10.0 QC21

FINAL INSPECTION/W/O RELEASE



08/05/2008

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-05-28

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

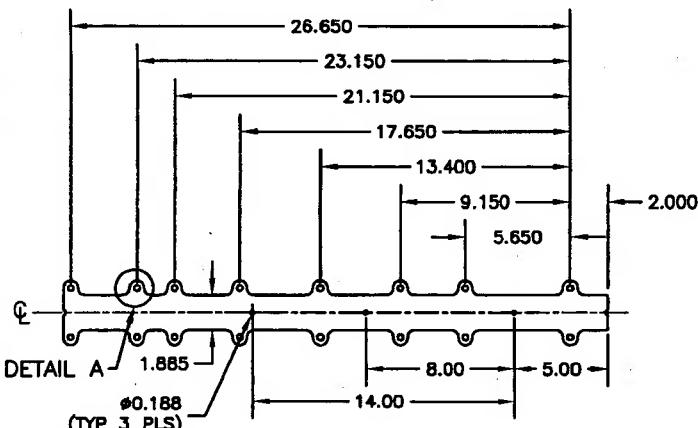
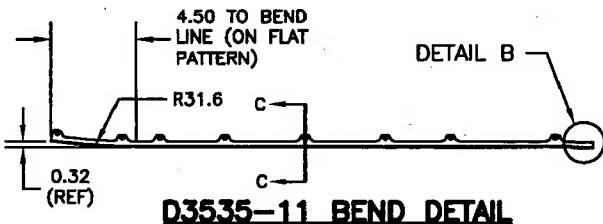
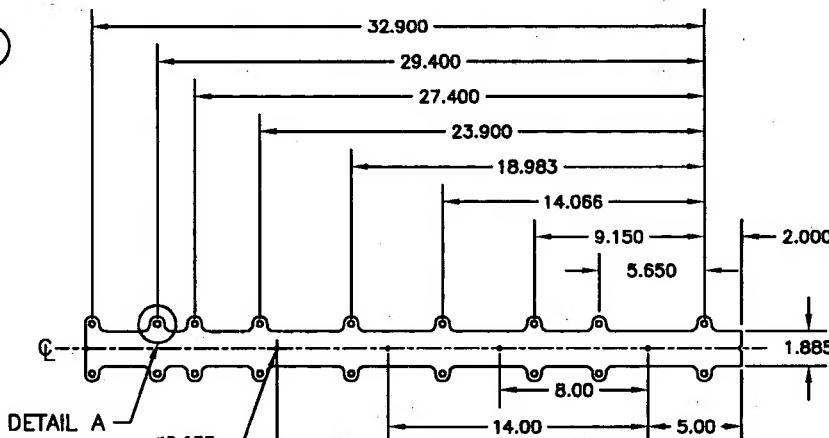
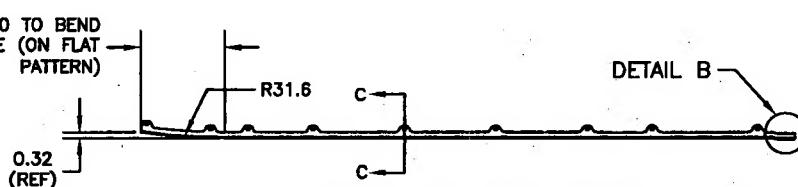
DART AEROSPACE LTD	Work Order:	39233
Description: Wearshoe	Part Number:	D3535-35
Inspection Dwg: D3535	Rev: B	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article Prototype

Measured by:	<u>AB</u>	Audited by:	<u>C</u>	Prototype Approval:	N/A
Date:	8-5-27	Date:	09/05/27	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.10	New Issue	KJ/JLM	E

**DART****D3535-11F FLAT PATTERN****D3535-11 BEND DETAIL****D3535-13F FLAT PATTERN****D3535-13 BEND DETAIL**

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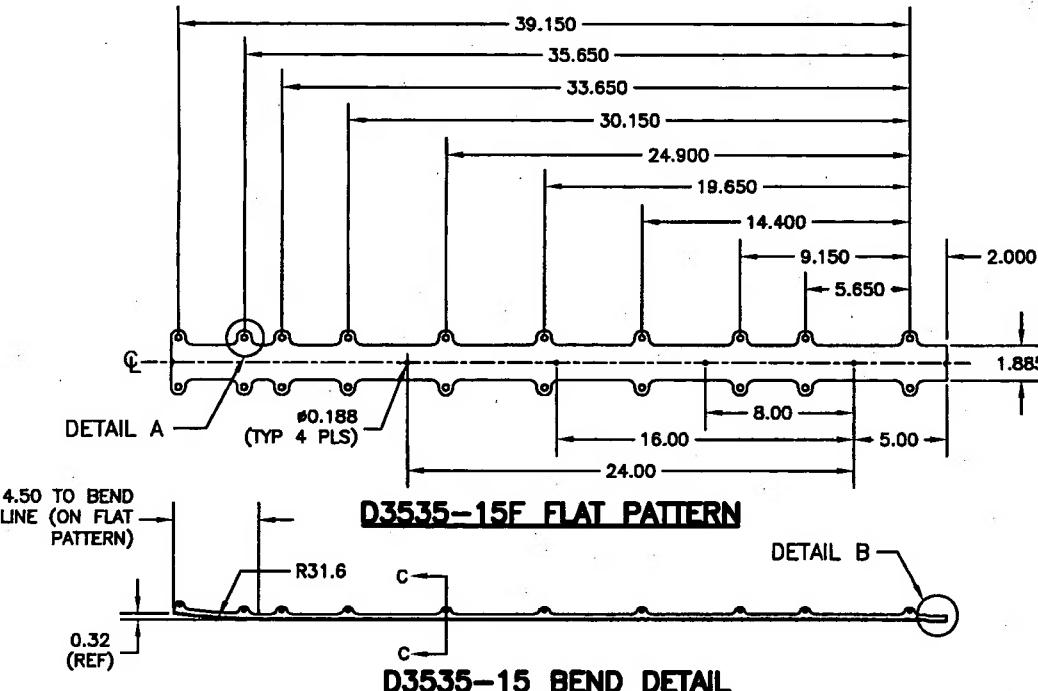
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- MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524.  
20 GAUGE (0.038 THICK)  
(REF DART SPEC M304S20GA)
  - FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER  
QSI 005 4.3
  - PART IS SYMMETRICAL ABOUT  $\frac{C}{2}$
  - TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED
  - ALL DIMENSIONS ARE IN INCHES
  - BREAK ALL SHARP EDGES TO 0.010 MAX
  - IDENTIFY WITH DART P/N USING WHITE FINE POINT  
PAINT MARKER
  - SEE PAGE 7 FOR DETAILS AND SECTION

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	REV. B
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 7
DATE		TITLE	SCALE
07.04.17	<u>PH</u>	D3535	
A	06.10.25	WEARSHOE	
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC	1:10

RELEASED  
07.04.24

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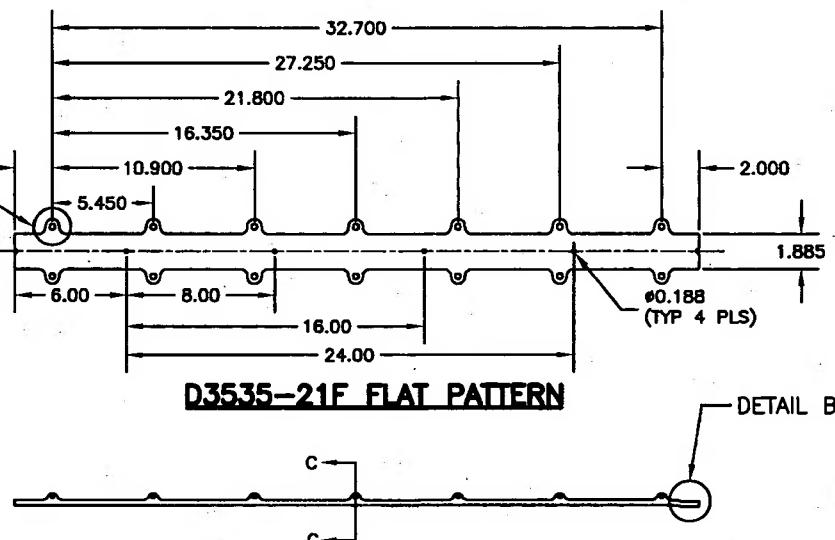
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DATE <b>07.04.17</b>	TITLE <b>WEARSHOE</b>	REV. B SHEET 2 OF 7 SCALE <b>1:10</b>

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(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER  
QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT  $\frac{1}{4}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT  
PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

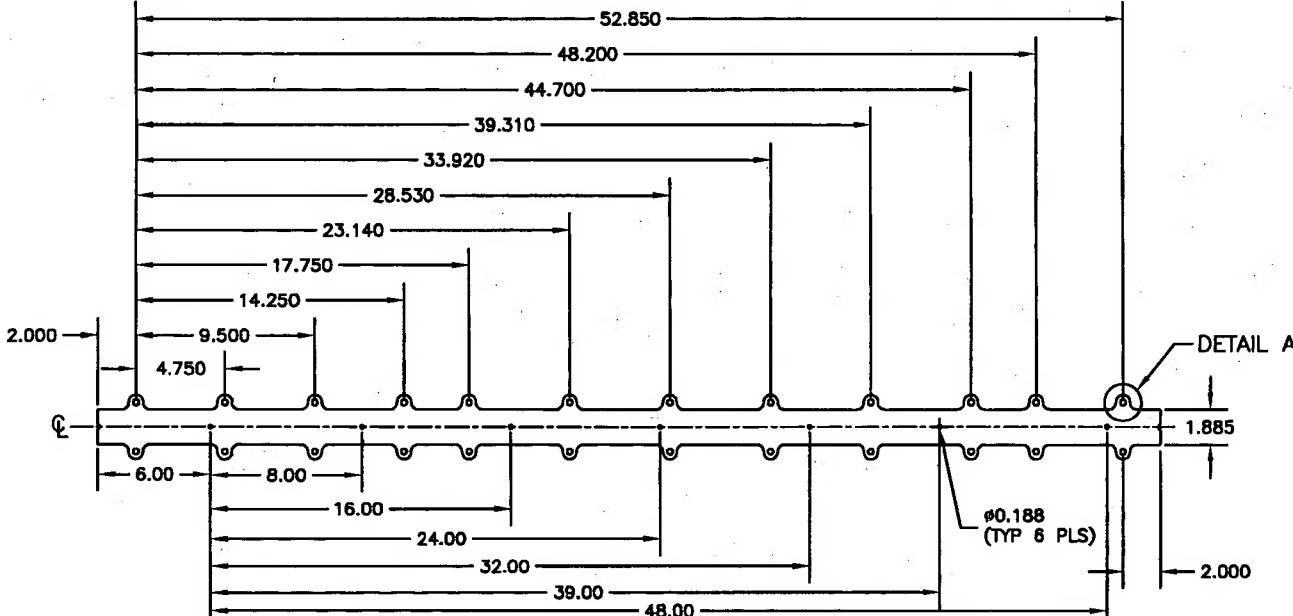
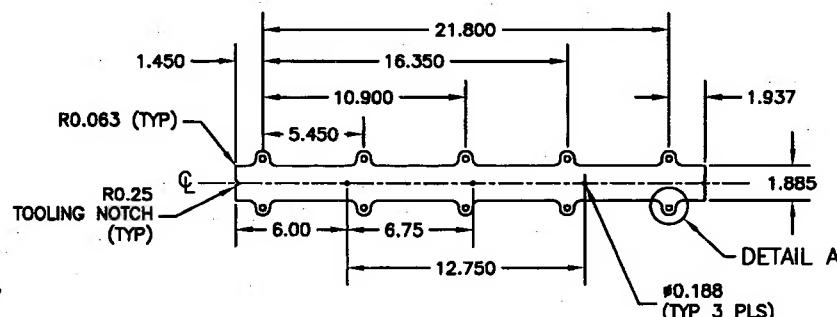


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DATE 07.04.17	TITLE WEARSHOE	REV. B SHEET 3 OF 7 SCALE 1:10

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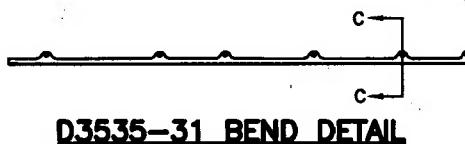
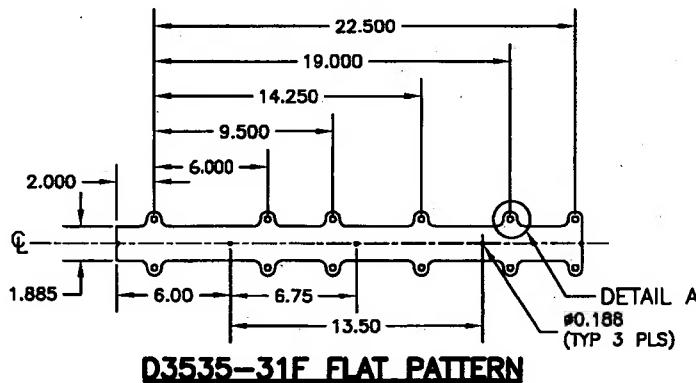
07.04.24

**D3535-23F FLAT PATTERN****D3535-23 BEND DETAIL****D3535-25F FLAT PATTERN****D3535-25 BEND DETAIL****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT  $\frac{1}{4}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

**DART**

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07.04.24

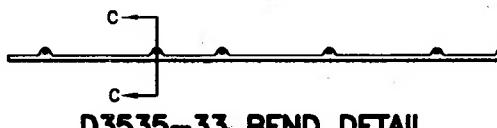
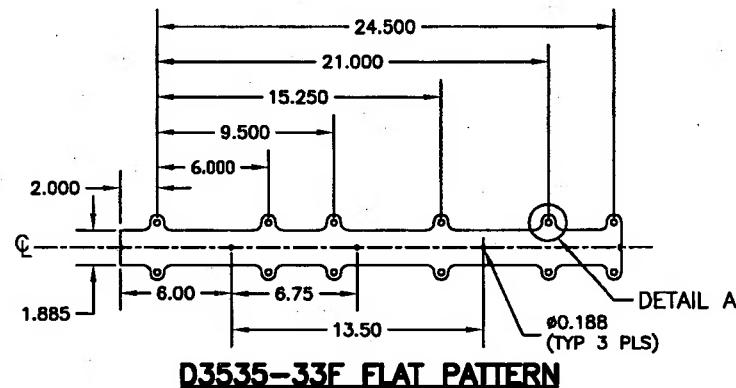


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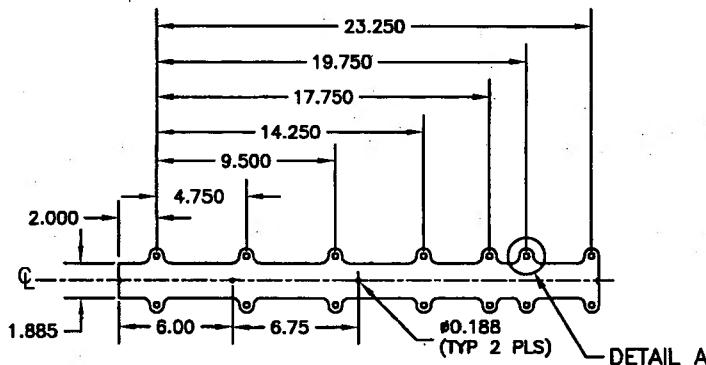
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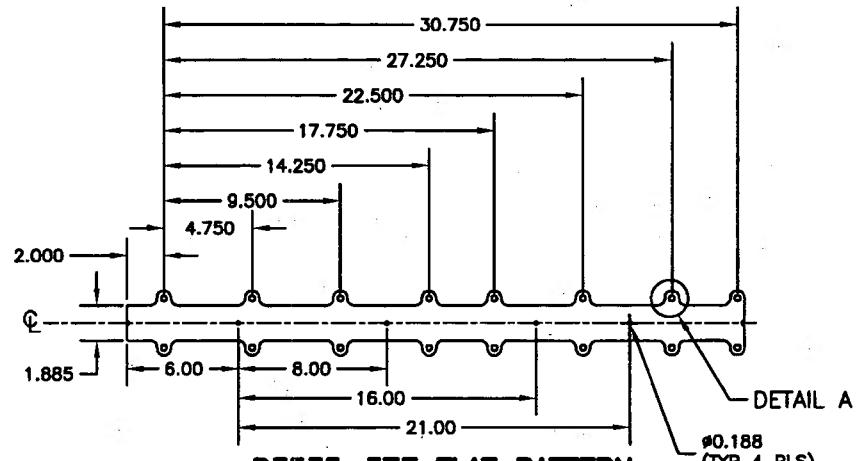
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DATE 07.04.17	TITLE WEARSHOE	REV. B SHEET 4 OF 7 SCALE 1:10

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07.04.14**D3535-35F FLAT PATTERN****D3535-35 BEND DETAIL**

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**D3535-37F FLAT PATTERN****D3535-37 BEND DETAIL**

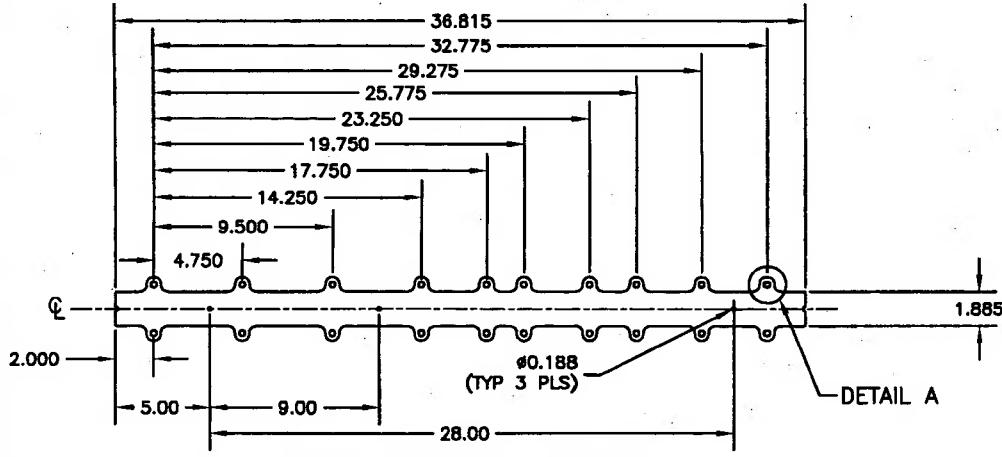
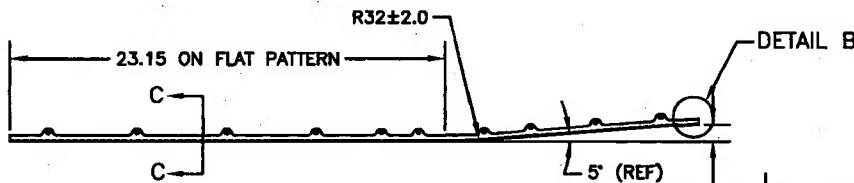
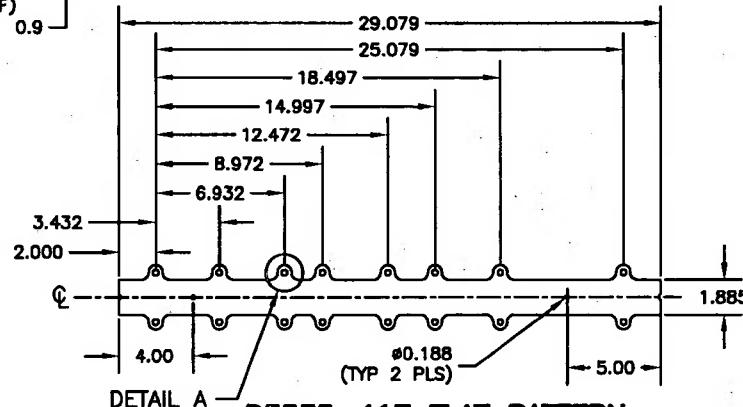
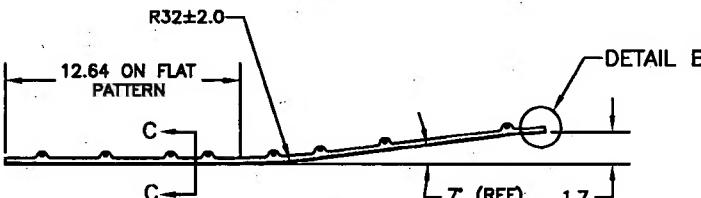
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DATE <b>07.04.17</b>		TITLE <b>WEARSHOE</b>

REV. B  
SHEET 5 OF 7  
SCALE  
1:10

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**D3535-39F FLAT PATTERN****D3535-39 BEND DETAIL****D3535-41F FLAT PATTERN****D3535-41 BEND DETAIL**

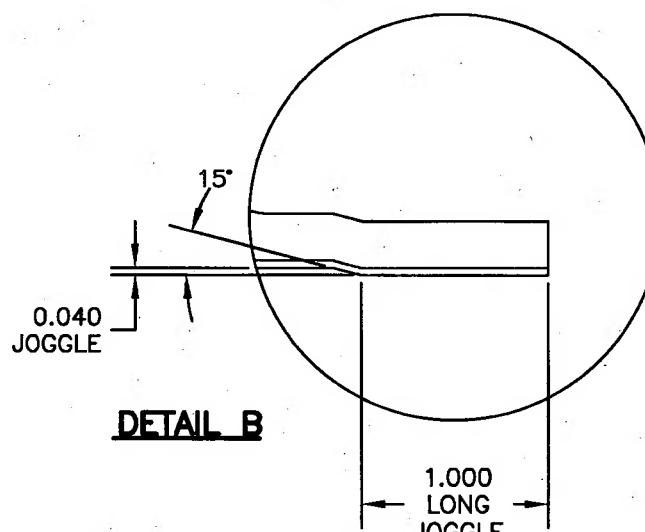
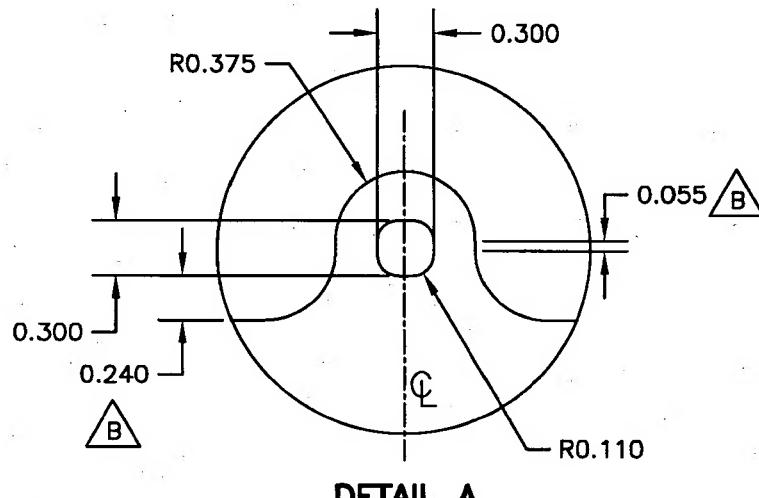
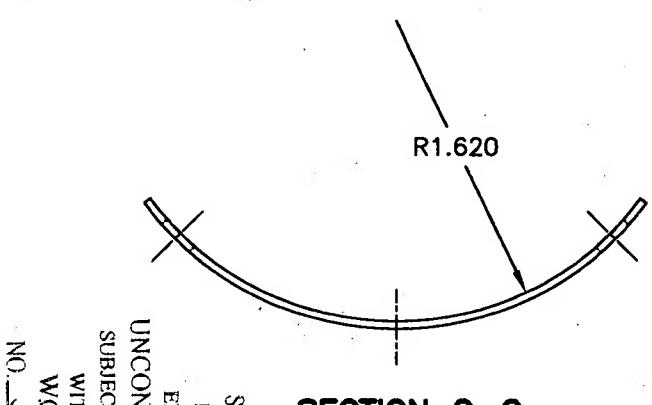
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DATE 07.04.17	TITLE WEARSHOE	REV. B SHEET 6 OF 7 SCALE 1:10

**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524,  
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DATE <b>07.04.17</b>	TITLE <b>WEARSHOE</b>	REV. B SHEET 7 OF 7 SCALE <b>1:1</b>

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07.04.24 *[Signature]***DETAIL B****DETAIL A****SECTION C-C**

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